



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2739
Job Sheet 187155



Part No: D2739

Job Qty: ~~10 ea~~ 8 JTW

Part Name: 350 I-Beam



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/28/18

Job Tracking No:

Due Date: 12/21/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG D2739 REV E IPP Rev: C 02.11.28 Reformat KJ IPP Rev: D 06-03-21 As Per Rev C JLM IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev: F 10.11.02 as per rev E DD ver: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		12/21/18	0.00	0.00	Start Up Skidtubes-2		TF
100	Skidtubes	10 pcs		12/21/18	0.00	5.41	Skidtubes-3		TF
120	HandFinish	10 pcs		12/21/18	0.00	0.83	HandFinish1		2018/12/18/31
130	QC	10 pcs		12/21/18	0.00	0.00	QC5		BE
140	Packaging	10 pcs		12/21/18	0.00	0.00	Packaging3-1		BE
150	QC21-SA	10 Ea		12/21/18	0.00	0.00	QC21		21 JAN 02 2019

Part Op **100** - 1-Cut D2600-5 to length as per Dwg D2739. 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 3-Descriptions: Use uni-bit to open holes to finish size as per Dwg D2739. 4-Bevel Fwd end of extrusion and Deburr holes and ends.

140 - LOCATION : LG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-5-108	Extrusion I-Beam Thin	10 pcs (1 ea)	90-Start up Operation	B145248

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-5-108	10	2	0

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework _____
Scrap _____
Use-as-is _____

Date : _____

Sequence #: _____

Description Work Order Deviation

DART
AEROSPACE
Container No: **S140949**
Part: **D2739**
Job No: **187155**
Serial No/Batch: **S140949**
Revision: _____
Inspector: _____
Exp Date: _____
Instructions: Various STC's

Date: 12/31/18

Dart Aerospace Ltd.
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CANADA
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www.dartaerospace.com

QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong
☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance
☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing
☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish
☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread
☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	

Other/Details: _____

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Web	78.760Inches $\pm$ 0.030	78.790 78.730		
2	Web	1.180Inches $\pm$ 0.010	1.190 1.170		
3	Web	3.150Inches $\pm$ 0.010	3.160 3.140		
4	Web	1.180Inches $\pm$ 0.010	1.190 1.170		
5	Web	0.250Inches $\pm$ 0.030	0.280 0.220		
6	Web	30.000Degrees + 0.500 - 5.000	30.500 25.000	Angle	
7	Web	1.250Inches $\pm$ 0.030	1.280 1.220		
8	Web	7.880Inches $\pm$ 0.030	7.910 7.850		
9	Web	10.070Inches $\pm$ 0.030	10.100 10.040		
10	Web	12.990Inches $\pm$ 0.030	13.020 12.960		
11	Web	16.540Inches $\pm$ 0.030	16.570 16.510		
12	Web	20.870Inches $\pm$ 0.030	20.900 20.840		
13	Web	25.200Inches $\pm$ 0.030	25.230 25.170		
14	Web	29.530Inches $\pm$ 0.030	29.560 29.500		
15	Web	32.650Inches $\pm$ 0.030	32.680 32.620		
16	Web	33.860Inches $\pm$ 0.030	33.890 33.830		
17	Web	35.350Inches $\pm$ 0.030	35.380 35.320		
18	Web	38.280Inches $\pm$ 0.030	38.310 38.250		
19	Web	41.350Inches $\pm$ 0.030	41.380 41.320		
20	Web	44.350Inches $\pm$ 0.030	44.380 44.320		
21	Web	47.400Inches $\pm$ 0.030	47.430 47.370		
22	Web	50.150Inches $\pm$ 0.030	50.180 50.120		
23	Web	52.900Inches $\pm$ 0.030	52.930 52.870		
24	Web	64.060Inches $\pm$ 0.030	64.090 64.030		
25	Web	70.270Inches $\pm$ 0.030	70.300 70.240		
26	Web	73.020Inches $\pm$ 0.030	73.050 72.990		
27	Web	75.770Inches $\pm$ 0.030	75.800 75.740		
28	Web	56.150Inches $\pm$ 0.030	56.180 56.120		

Plex 11/28/18 10:33 AM dart.white.jesse

Entered: _____ Date: _____

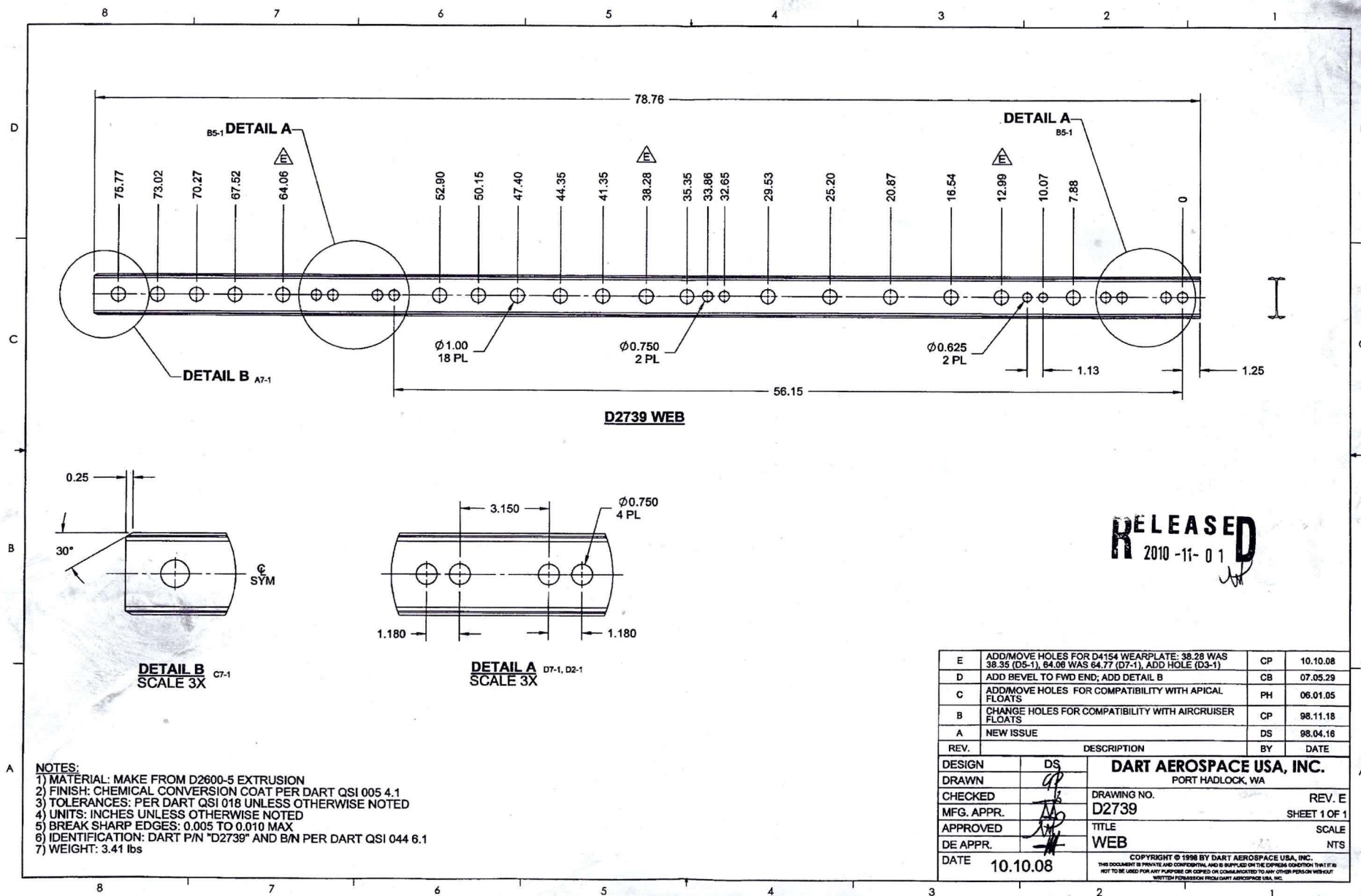


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



RELEASED
2010-11-01

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date :	Sequence #:	QTY Affected :			MRB (QSI042)		
Description Work Order Deviation		Disposition			Completed By		
					Lead hand / Supervisor		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
Other/Details: _____							